

Date: Tuesday, 26/08/2008 7:23:37 AM

User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 41239	Customer	: Dart Helicopters Services
Estimate Number	: 13532	DWG Name	: AFT BLADE FOLD ASSEMBLY
Purchase Order #	:	Part Number	: PB674300103
Complete Date	: / / : : AM	DWG Number	: B6743001 P.1,3,4,15
		Rev.	: B1

47.0 3408A98-DETENT BALL SPRING PLUNG INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
15/08/2008	SAUV02: Sauve, Amy	3408A98	3.000		\$15.66	Lot # 102812 Qty. 3

Subtotal: QTD: 0 CTD: 3 \$15.66

		TIME	COST
	Machine Time:	0.00	\$0.00
	Labor:	0.00	\$0.00
	Sub-contract (external Op.):		\$0.00
	INVENTORY ITEM:		\$486.89
	SUB-COMPONENT (SUB-JOB):		\$0.00
Total:			\$486.89

COST PER UNIT: \$486.89

Date: ✓ Tuesday, 26/08/2008 7:23:36 AM

User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 41239	Customer	: Dart Helicopters Services
Estimate Number	: 13532	DWG Name	: AFT BLADE FOLD ASSEMBLY
Purchase Order #	:	Part Number	: PB674300103
Complete Date	: / / : : AM	DWG Number	: B6743001 P.1,3,4,15
		Rev.	: B1

38.0 AN620A-Bolt INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
15/08/2008	SAUV02: Sauve, Amy	AN620A	6.000		\$2.74	Lot # 104547 Qty. 6
Subtotal:		QTD:	0	CTD:	6	\$2.74

39.0 AN813A-BOLT INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
15/08/2008	SAUV02: Sauve, Amy	AN813A	6.000		\$7.50	Lot # 18180 Qty. 6
Subtotal:		QTD:	0	CTD:	6	\$7.50

40.0 BSP43-RIVET INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
15/08/2008	SAUV02: Sauve, Amy	BSP43	9.000		\$1.44	Lot # 17890 Qty. 9
Subtotal:		QTD:	0	CTD:	9	\$1.44

41.0 CR3213405-cherry rivet INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
15/08/2008	SAUV02: Sauve, Amy	CR3213405	3.000		\$1.74	Lot # 104214 Qty. 3
Subtotal:		QTD:	0	CTD:	3	\$1.74

42.0 MS17984C413-PIN, QUICK RELEASE INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
15/08/2008	SAUV02: Sauve, Amy	MS17984C413	3.000		\$81.06	Lot # 18119 Qty. 3
Subtotal:		QTD:	0	CTD:	3	\$81.06

43.0 MS17984C418-PIN, QUICK RELEASE INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
15/08/2008	SAUV02: Sauve, Amy	MS17984C418	6.000		\$120.80	Lot # 108473 Qty. 6
Subtotal:		QTD:	0	CTD:	6	\$120.80

44.0 30345T21-LANYARD INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
15/08/2008	SAUV02: Sauve, Amy	30345T21	3.000		\$7.46	Lot # 102812 Qty. 3
Subtotal:		QTD:	0	CTD:	3	\$7.46

45.0 30345T24-LANYARDS INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
15/08/2008	SAUV02: Sauve, Amy	30345T24	9.000		\$24.83	Lot # 108390 Qty. 6 Lot # 18351 Qty. 3
Subtotal:		QTD:	0	CTD:	9	\$24.83

46.0 240107-SPRING SLOTTED PIN INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
15/08/2008	SAUV02: Sauve, Amy	240107	27.000		\$3.25	Lot # 102940 Qty. 27
Subtotal:		QTD:	0	CTD:	27	\$3.25

Date: Tuesday, 26/08/2008 7:23:36 AM

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		Rev.	: B1

29.0 NAS1149F0316P-WASHER INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
15/08/2008	SAUV02: Sauve, Amy	NAS1149F0316P	3.000		\$0.40	Lot # 106242 Qty. 3
Subtotal:		QTD:	0	CTD:	3	\$0.40

30.0 NAS1149F0432P-Washer INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
15/08/2008	SAUV02: Sauve, Amy	NAS1149F0432P	48.000		\$0.96	Lot # 18057 Qty. 48
Subtotal:		QTD:	0	CTD:	48	\$0.96

31.0 NAS1149F0632P-WASHER INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
15/08/2008	SAUV02: Sauve, Amy	NAS1149F0632P	24.000		\$0.48	Lot # 18057 Qty. 24
Subtotal:		QTD:	0	CTD:	24	\$0.48

32.0 NAS1149F0832P-WASHER INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
15/08/2008	SAUV02: Sauve, Amy	NAS1149F0832P	12.000		\$0.12	Lot # 18057 Qty. 12
Subtotal:		QTD:	0	CTD:	12	\$0.12

33.0 AN960JD6-Washer INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
15/08/2008	SAUV02: Sauve, Amy	AN960JD6	3.000		\$0.03	Lot # 6085 Qty. 3
Subtotal:		QTD:	0	CTD:	3	\$0.03

34.0 AN410A-Bolt INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
15/08/2008	SAUV02: Sauve, Amy	AN410A	6.000		\$1.44	Lot # 105442 Qty. 6
Subtotal:		QTD:	0	CTD:	6	\$1.44

35.0 AN413A-Bolt INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
15/08/2008	SAUV02: Sauve, Amy	AN413A	3.000		\$0.85	Lot # 107959 Qty. 3
Subtotal:		QTD:	0	CTD:	3	\$0.85

36.0 AN416A-Bolt INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
15/08/2008	SAUV02: Sauve, Amy	AN416A	12.000		\$4.99	Lot # 19278 Qty. 12
Subtotal:		QTD:	0	CTD:	12	\$4.99

37.0 AN611A-BOLT INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
15/08/2008	SAUV02: Sauve, Amy	AN611A	6.000		\$2.18	Lot # 105558 Qty. 6
Subtotal:		QTD:	0	CTD:	6	\$2.18

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Purchase Order #	:	Part Number	: PB674300103
Complete Date	: / / : : AM	DWG Number	: B6743001 P.1,3,4,15
		Rev.	: B1

DUE DATE	ORDERED	DELIVERED
18/08/2008	3	0

17.0 D34401-Tube Guide	INVENTORY ITEM				
DATE	EMPLOYEE	TYPE	Qty	COST	
15/08/2008	SAUV02: Sauve, Amy	D34401	1.000	\$180.70	Lot # 23949 Qty. 1
Subtotal:	QTD:	0	CTD:	1	\$180.70

21.0 086004-Inventory	INVENTORY ITEM				
DATE	EMPLOYEE	TYPE	Qty	COST	
15/08/2008	SAUV02: Sauve, Amy	086004	3.000	\$0.30	Lot # 17850 Qty. 3
Subtotal:	QTD:	0	CTD:	3	\$0.30

22.0 MS27039107-Screw	INVENTORY ITEM				
DATE	EMPLOYEE	TYPE	Qty	COST	
15/08/2008	SAUV02: Sauve, Amy	MS27039107	3.000	\$0.24	Lot # 18057 Qty. 3
Subtotal:	QTD:	0	CTD:	3	\$0.24

23.0 MS27039123-SCREW	INVENTORY ITEM				
DATE	EMPLOYEE	TYPE	Qty	COST	
15/08/2008	SAUV02: Sauve, Amy	MS27039123	3.000	\$0.51	Lot # 18057 Qty. 3
Subtotal:	QTD:	0	CTD:	3	\$0.51

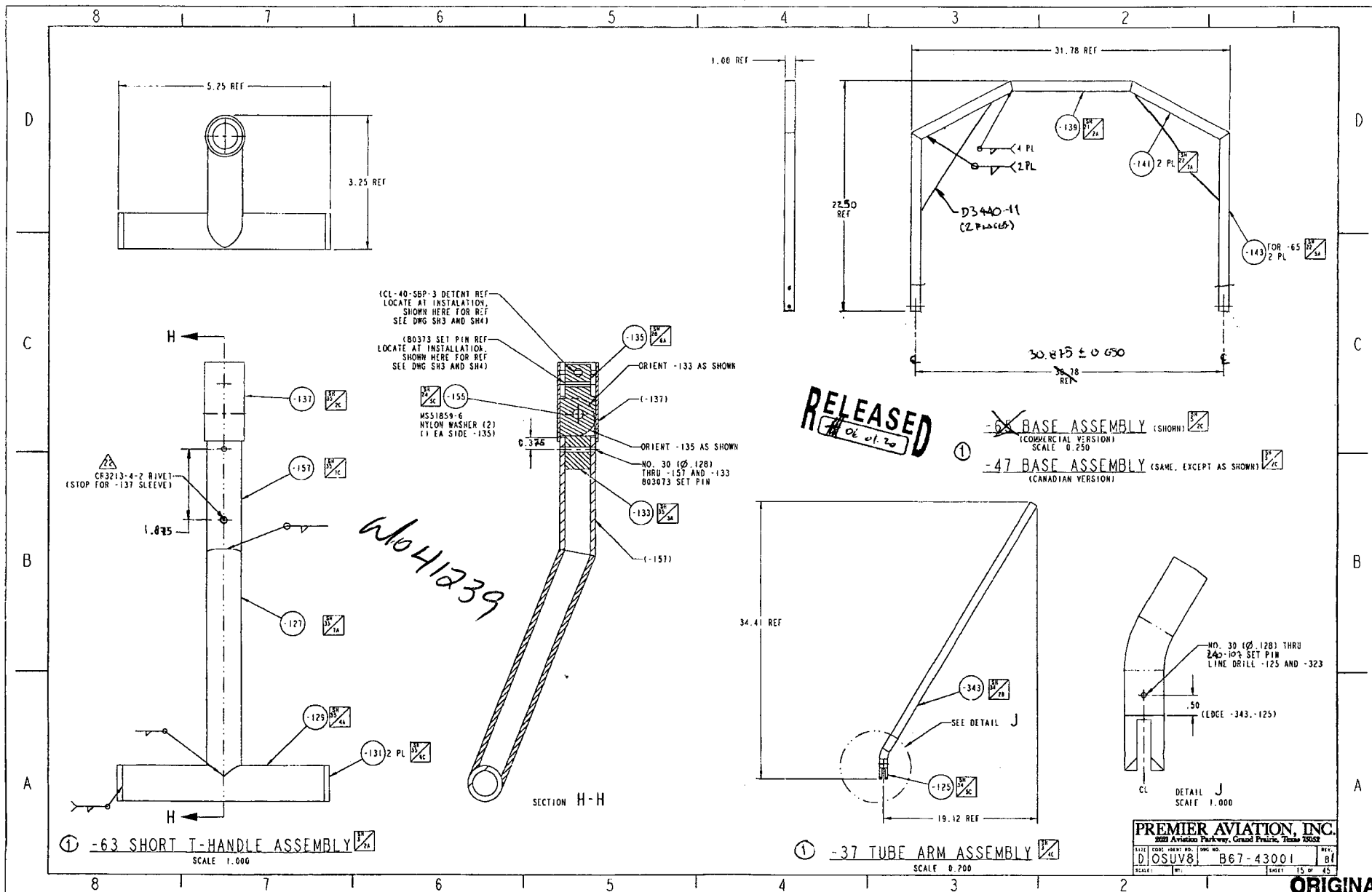
24.0 MS21042L4-Nut	INVENTORY ITEM				
DATE	EMPLOYEE	TYPE	Qty	COST	
15/08/2008	SAUV02: Sauve, Amy	MS21042L4	39.000	\$6.65	Lot # 108480 Qty. 39
Subtotal:	QTD:	0	CTD:	39	\$6.65

25.0 MS21042L6-Nut	INVENTORY ITEM				
DATE	EMPLOYEE	TYPE	Qty	COST	
15/08/2008	SAUV02: Sauve, Amy	MS21042L6	12.000	\$7.44	Lot # 105077 Qty. 12
Subtotal:	QTD:	0	CTD:	12	\$7.44

26.0 MS518596-WASHER	INVENTORY ITEM				
DATE	EMPLOYEE	TYPE	Qty	COST	
15/08/2008	SAUV02: Sauve, Amy	MS518596	24.000	\$7.54	Lot # 106277 Qty. 5 Lot # 108473 Qty. 19
Subtotal:	QTD:	0	CTD:	24	\$7.54

27.0 MS518598-WASHER	INVENTORY ITEM				
DATE	EMPLOYEE	TYPE	Qty	COST	
15/08/2008	SAUV02: Sauve, Amy	MS518598	18.000	\$2.70	Lot # 18854 Qty. 18
Subtotal:	QTD:	0	CTD:	18	\$2.70

28.0 NAS43DD368-SPACER	INVENTORY ITEM				
DATE	EMPLOYEE	TYPE	Qty	COST	
15/08/2008	SAUV02: Sauve, Amy	NAS43DD368	3.000	\$2.88	Lot # 108473 Qty. 3
Subtotal:	QTD:	0	CTD:	3	\$2.88

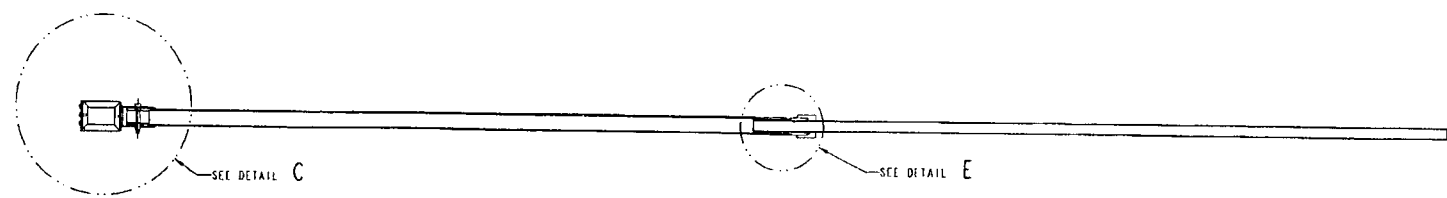


PREMIER AVIATION, INC.
 3000 Aviation Parkway, Grand Prairie, Texas 75050
 SIZE: D OSUV8 B67-43001
 SCALE: 15 OF 45

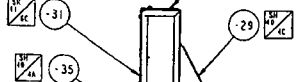
ORIGINAL

RELEASED

8 7 6 5 4 3 2



MS27039-1-09 SCREW
NAS1149F0316P WASHER
Ø.193 THRU
MATCH DRILL -29 WITH NUTPLATE
LOC'S OF -35
7 PLACES

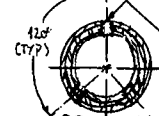


3.64

123.55 REF

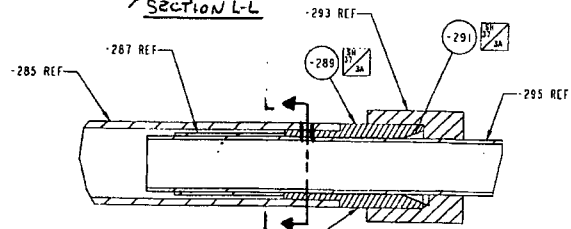
① -27 BLADE POSITIONER

FULLY EXTENDED THIS VIEW
SCALE 0.200



DRILL Ø0.159 (Ø21 DRILL) AND
TAP Ø0.132 UNF
(3 PLACES)

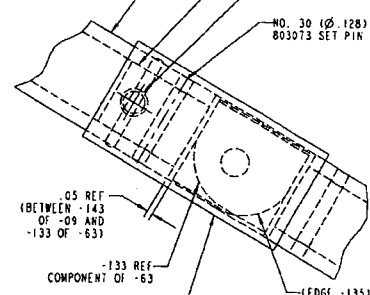
SECTION L-L



-243 REF (COMPONENT OF -09 ASSY)

135 REF (COMPONENT OF -63)
SCREWS DETENT CIRC PIN

NO. 30 (Ø.128) THRU
803073 SET PIN



Ø5 REF
(BETWEEN -143
OF -09 AND
-133 OF -63)

-133 REF
COMPONENT OF -63

135 REF (COMPONENT OF -63)
SCREWS DETENT CIRC PIN

INSERT -135 (COMPONENT
OF -63 ASSY) INTO -243 TUBE
(COMPONENT OF -09 ASSY)
ALIGN HOLES, ASSURING ORIENTATION
SHOWN. INSERT 803073
BALL, ASSURING BALL PROTRUDES SLIGHTLY
ABOVE OUTER SURFACE OF -243 TUBE.
LOCATE 803073 SET PIN. ASSURE -137
SLEEVE SLIDES FREELY OVER HINGE AND
LOCKS INTO DETENT.

DETAIL B
SCALE 2.000
(-03 ASSY)

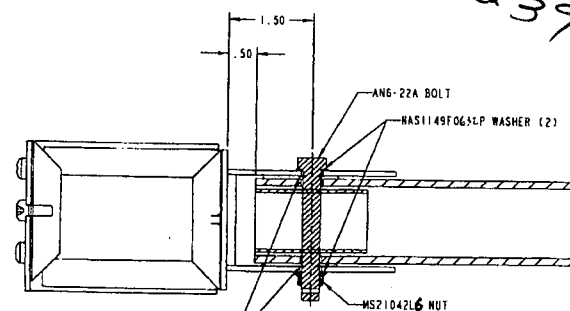
PREMIER AVIATION, INC.

8001 Aviation Parkway, Grand Prairie, Texas 75052

DATE: 08/01/88
EQUIP. IDENT. NO.: B67-43001
SCALE: 1:1
SHEET: 4 OF 45

ORIGINAL

No 41239



MS1859-8 NYLON WASHER (2)

DETAIL C
SCALE 1.000
(-27 ASSY)

DETAIL E
SCALE 1.000
(-27 ASSY)

8 7 6 5 4 3 2

[illegible]

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
A	MFG. RELEASE	10/12/95	WH
B	CHANGES TO IMPROVE FUNCTIONALITY	3/7/96	WH
B	DWG AND P/L REVISED AND UPDATED	8/15/96	N/A
	TO REFLECT BELT MODIFICATIONS		
B3	CHANGED DESIGN AFTER FIT	4/30/97	


1. IDENTIFY PARTS PER PREMIER IDENTIFICATION AND MARKING PROCEDURES 115-12112. LOCATION, CHARACTER HEIGHT, AND PROCESS AS REQUIRED. MARK IN CONTRASTING COLOR.
2. FOR SHEET METAL PARTS, REMOVE ALL BURRS AND BREAK ALL EDGES/CORNERS .01-.03, EXCEPT AS NOTED. FOR MACHINED PARTS, REMOVE ALL BURRS AND BREAK ALL EDGES/CORNERS .015 MAX, EXCEPT AS NOTED.
3. GENERAL SHOP PRACTICES I.A.W. PREMIER SPEC. 008-93000 AND AC43.13.
4. OPEN
5. WELD PARTS PER MIL-2719, CLASS B.
6. CHEM FILM (ALODINE) ALL ALUMINUM DETAIL PARTS PER PREMIER SPEC 008-93003, CLASS 11 AND PRIME WITH EPOXY PRIMER PER MIL-P-23377C, ZINC CHROMATE PRIMER PER MIL-ITP-1757, OR EQUIVALENT.
7. STITCHING PER FED-STD-751.

21. SECURE -43 BELT ASSY TO TOP OF -65 (OF -85) OR -47 (OF -67) LOCATF APPROX AS SHOWN.
22. WITH -137 SLEEVE IN OPEN POSITION, LOCATE RIVET APPROX AS SHOWN, TO SERVE AS A STOP FOR -137
23. DRILL WITH -37 AT VERTICAL FULL OPEN POSITION. DRILL ADDITIONAL HOLE WITH -37 AT FULL CLOSED POSITION, ASSURING -37 CLEARS ADJACENT STRUCTURE.
24. SHIM AS REQD. USING NAS1149D0332J WASHERS.
25. -01 FWD BLADEFOLD ASSY FOR COMMERCIAL VERSIONS ONLY
-02 FWD BLADEFOLD ASSY FOR CANADIAN VERSIONS ONLY
26. TOLERANCE ON DECIMAL .X ± .1
27. LAST SECTION LETTER USED "L".
28. DRILL NO. 30 (Ø.128) HOLE THRU -37 AND -25 (COMPONENT OF -09 ASSY). INSERT 8003075 SET PIN, AND GRIND FLUSH WITH -37.

8 WITH THE INNER TUBE CRADLE ASSEMBLY LOCKED IN ITS MOST EXTENDED POSITION (1-HANDLE LOCKED ON LOWEST HOKE), DRILL A .25 DIA HOLE THROUGH THE OUTER TUBE .35 BELOW THE BOTTOM OF THE INNER TUBE AND INWARD FROM THE OUTER SIDE OF THE OUTER TUBE. UNLOCK THE INNER TUBE CRADLE ASSEMBLY AND MOVE IT TO ITS LOWEST, MOST RESESSED POSITION. WATCH DRILL THE INNER TUBE TO THE HOLE JUST DRILLED IN THE OUTER TUBE. .25 DIA.


INSTALL TEFLON TUBE BUSHING INSIDE THE OUTER TUBE.
MATCH DRILL BUSHING TO EXISTING HOLES IN OUTER TUBE
USING 1/8" DIAMETER DRILL. INSERT 803073 SET PIN.
AND GRIND FLUSH WITH CONTOUR OF OUTER TUBE. 8 PL (2 PL EA BUSHING)

10 GRIND BUSHING AND WELD TO CONTOUR OF TUBE.

 ALIGN CRADLE ASSEMBLY
90 DEGREES FROM THE CENTERLINE AXIS OF THE
BUSHING ON THE OTHER END OF THE TUBE.
WELD GUSSET ON CENTER WITH TUBE AND BOTTOM
OF CRADLE ASSEMBLY.

 CHAMFER EDGE FOR BETTER WELDING

13 TAP HOLE TO 1/4-20 THRU

 INSTALL CL-40-SBP-3 DETENT BALL INTO HOLDING FIXTURE SO THAT THE BALL IS POSITIONED SLIGHTLY ABOVE FLUSH WITH THE TUBE SEAT SURFACE. ALIGN THE TUBE IN THE FIXTURE AND MARK THE BALL CONTACT LOCATION ON THE TUBE. USE A SMALL PUNCH TO DIMPLE THE TUBE AT THE MARKED LOCATION. INSERT THE TUBE BACK INTO THE FIXTURE AND ADJUST FOR PROPER SLOWING.

15. PERMISSIBLE TO SUBSTITUTE EQUIVALENT AN960 WASHER FOR NAS1149 WASHER UNTIL CURRENT STOCK IS DEPLETED.

16. PAINT ALL ASSEMBLIES AND WELDMENTS AS REQUIRED.
EXCEPT WHERE NOTED, 23663U W OHS A YELLOW. PER FED-STD-525.

 NO PAINT REQUIRED. CHEM FILM ONLY WHERE APPLICABLE.
PER PREMIER SPEC 008-93003.

18 STITCH APPROX AS SHOWN, PER FED-STD-751.

19 PERMISSIBLE TO TRIM NYLON WASHERS OR SUBSTITUTE WITH THINNER MSS1859 EQUIVALENT.

DISENGAGE -53 HANDLE ASSY (BOTH SIDES) PRIOR TO INSTALLATION AND REMOVAL OF -01 OR -02 BLADEFOLD ASSY TO AIRCRAFT

RELEASED
06-01-20

ECO
5007
5161
6262

W/O 41239

SEE SEPARATE PARTS LIST B67-43001PI

MATERIAL	DIMENSIONS LIST PER INCHES TOLERANCES	UNLESS OTHERWISE SPECIFIED:		DATE	PREMIER AVIATION, INC. 3020 Aviation Parkway, Grand Prairie, Texas 75059
		DECIMALS	ANGLES	01/12/75	
FINISH	USED 6561429 141212P	± .005	± 1/2°	CHECKED BY: RICK REYNOLDS	DATE 01/12/75
		± .010		APPROVED BY: WALT HAMAKER	DATE 01/12/75
		RECEIVED BY: PROF. ENGINEER	DATE	TITLE BLADE FOLD KIT	
		SIZE	QTY	UNIT	REV
		D10SLVB8	B67-43001		B
		UN			

ORIGINAL

Date: Thursday, 14/08/2008 10:58:51 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 41239

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

48.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per dwg and use 242 threadlock A/R shown on dwg PB67-43001 page 2.

242 THREADLOCK batch: M 107045

08.08.26

49.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/08/26

50.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

39952

51.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/27

Job Completion



08/08/26

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 41239

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

CR3213405

cherry rivet



M18119



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

cherry rivet

batch:

M104214

✓

AS 08/08/15 (X3)

42.0

MS17984C413

PIN, QUICK RELEASE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

PIN, QUICK RELEASE

batch:

M18119

AS 08/08/15 (X3)

43.0

MS17984C418

PIN, QUICK RELEASE



Comment: Qty.: 3.0000 Each(s)/Unit Total: 9.0000 Each(s)

PIN, QUICK RELEASE

batch:

M18119 M108473 Y6

✓

AS 08/08/15 (X3)

44.0

30345T21

LANYARD



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

LANYARD

batch:

M182812

✓

AS 08/08/15 (X3)

45.0

30345T24

LANYARDS



Comment: Qty.: 3.0000 Each(s)/Unit Total: 9.0000 Each(s)

LANYARDS

batch:

M18351 X3 M108390 Y6

✓

AS 08/08/15 (X3)

46.0

240107

SPRING SLOTTED PIN



Comment: Qty.: 9.0000 Each(s)/Unit Total: 27.0000 Each(s)

SPRING SLOTTED PIN

batch:

M102990

✓

AS 08/08/15 (X3)

47.0

3408A98

DETENT BALL SPRING PLUNG



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

DETENT BALL SPRING PLUNG

batch:

M102812

✓

AS 08/08/15

Date: Thursday, 14/08/2008 10:58:50 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 41239

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

AN410A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

batch:

M105442

✓

SS 08/08/15 (K3)

35.0

AN413A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bolt

batch:

M167959

✓

SS 08/08/15 (K3)

36.0

AN416A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bolt

batch:

M19278

✓

SS 08/08/15 (K3)

37.0

AN611A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

BOLT

batch:

M165558

✓

SS 08/08/15 (K3)

38.0

AN620A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

batch:

104547

✓

SS 08/08/15 (K3)

39.0

AN813A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

BOLT

batch:

M18180

✓

SS 08/08/15 (K3)

40.0

BSP43

RIVET



Comment: Qty.: 3.0000 Each(s)/Unit Total : 9.0000 Each(s)

RIVET

batch:

17890

✓

SS 08/08/15 (K3)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 41239

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

MS518598

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 24.0000 Each(s)

WASHER

batch:

M18854x18

JS 08/08/15 (X3)

28.0

NAS43DD368

SPACER



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

SPACER

batch:

M108473

JS 08/08/15 (X3)

29.0

NAS1149F0316P

WASHER



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

WASHER

batch:

M106242

JS 08/08/15 (X3)

30.0

NAS1149F0432P

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total: 48.0000 Each(s)

Washer

batch:

18057

JS 08/08/15 (X3)

31.0

NAS1149F0632P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 24.0000 Each(s)

WASHER

batch:

M18057

JS 08/08/15 X3

32.0

NAS1149F0832P

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 12.0000 Each(s)

WASHER

batch:

M18057

JS 08/08/15 (X3)

33.0

AN960JD6

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Washer

batch:

6085

JS 08/08/15 (X3)

Date: Thursday, 14/08/2008 10:58:50 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 41239

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

D34479

Swing Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)
Swing Arm
batch: 29968

NO QTY'S



comp says 20

12 08/08/26

21.0

086004

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)
Inventory
batch: M 17850



AS 08/08/15 (X3)

22.0

MS27039107

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)
Screw
batch: M 18057



AS 08/08/15 (X3)

23.0

MS27039123

SCREW



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)
SCREW
batch: M 18057



AS 08/08/18 (X3)

24.0

MS21042L4

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total: 39.0000 Each(s)
Nut
batch: M 108480



AS 08/08/15 (X3)

25.0

MS21042L6

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 12.0000 Each(s)
Nut
batch: 105077



AS 08/08/15 (X3)

26.0

MS518596

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 24.0000 Each(s)
WASHER
batch: M 106277⁵ x M 108473 x 19



AS 08/08/15 (X3)

Date: Thursday, 14/08/2008 10:58:50 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 41239

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PB6743001265

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total: 12.0000 Each(s)

Bushing

batch: 40056

U

08/08/26

14.0

PB6743001299

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Bushing

batch: 40062

U

08/08/26

15.0

D3451045

Handle and Lock-Down Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Handle and Lock-Down Assembly

batch: 41065

NO QTY

U

08/08/26

16.0

D3451047

Handle and Lock-Down Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Handle and Lock-Down Assembly

batch: 41063

NO QTY'S

U

08/08/26

17.0

D34401

Tube Guide



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Tube Guide

batch: AB23949 x1

NO QTY'S says comp 10?

SS

08/08/15 (3)

18.0

D34403

Clamp



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Clamp

batch: 39964

NO QTY'S comp says 5?

U

08/08/26

19.0

D34441

Velcro Loop Belt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Velcro Loop Belt

batch: 35548 x3

comp won't except Batch

SS

08/08/15 (3)

Date: Thursday, 14/08/2008 10:58:50 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 41239

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 PB674300137 PB67-43001-37



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

PB67-43001-37

batch: 40242

U

08/08/26

7.0 PB674300157 Stabilizer Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Stabilizer Arm

batch: 41014

U

08/08/26

8.0 PB674300159 PB67-43001-59



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

PB67-43001-59

batch: 40093

U

08/08/26

9.0 PB674300163 Handle Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Handle Assembly

batch: 40816

U

08/08/26

10.0 PB6743001135 Male Eye



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Male Eye

batch: 23995

U

08/08/26

11.0 PB6743001155 Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pin

batch: 40577

U

08/08/26

12.0 PB6743001261 Lever Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Lever Arm

batch: 40054

U

08/08/26

Date: Thursday, 14/08/2008 10:58:50 AM
User: Melanie Fauteux











Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT BLADE FOLD ASSEMBLY
Job Number	: 41239		
Estimate Number	: 13532		
P.O. Number	:	Part Number	: PB674300103
This Issue	: 14/08/2008 S.O. No. :	Drawing Number	: B6743001 P.1,3,4,15
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: B1
Previous Run	:	Material	:
Written By	:	Due Date	: 18/08/2008 Qty: 3 Um: Each
Checked & Approved By	: <u>MF 08-08-14</u>		
Comment	: Est Rev:A 08-07-30 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PB674300109	Aft Blade Fold Assembly Weldment
  <p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s) Aft Blade Fold Assembly Weldment batch: <u>40972</u> <i>h</i> 08/08/26</p>		
2.0	PB674300113	Aft Adjustable Blade Support Assembly
  <p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s) Aft Adjustable Blade Support Assembly batch: <u>40607</u> <i>h</i> 08/08/26</p>		
3.0	PB674300117	Aft Adjustable Blade Support Assembly
  <p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s) Aft Adjustable Blade Support Assembly batch: <u>40209</u> <i>h</i> 08/08/26</p>		
4.0	PB674300121	PB67-43001-21
  <p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s) PB67-43001-21 batch: <u>36953</u> <i>h</i> 08/08/26</p>		
5.0	PB674300123	PB67-43001-23
  <p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s) PB67-43001-23 batch: <u>36259</u> <i>h</i> 08/08/26</p>		